

Date: Monday, 28/07/2008 3:38:57 PM
 User: Lind Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LONG T-HANDLE ASSEMBLY
 Job Number : 40770
 Estimate Number : 13522
 P.O. Number :
 This Issue : 28/07/2008 S.O. No. :
 Prsht Rev. : NC Part Number : PB674300151
 First Issue : / / Type : SMALL /MED FAB Drawing Number : B6743001 P.13
 Previous Run : Drawing Revision : B1
 Written By : Material :
 Checked & Approved By : MC 08-07-28 Due Date : 04/08/2008 Qty: 3 Um: Each
 Comment : Est Rev:A 08-07-25 new issue DD verified by:ec

Additional Product

See attachment

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PB674300187 Tube Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Tube Arm

batch: M1079504 pulled mat.

PK 08-07-29 3

2.0 PB674300191 Tube Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Tube Handle

batch: M107950 18747 pulled mat

PK 08-07-29 3

3.0 PB674300193 Tube End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Tube End Cap

batch: 40074

PK 08-07-29 3

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- drill #40 hole in center of -91 before welding -93 caps, to let air out

2- weld -93 to -91 as per dwg

3- grind weld flush

4- assemble -87 under the pilot hole in -91 and weld as per dwg

PK 08-07-29 3

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50819/31 (A3)

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Seq. #:

Machine Or Operation:

Description :

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/07/11 (3)

7.0

PB674300189

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Clevis

batch: 323986

08-08-12 3

8.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

SPRING SLOTTED PIN

batch: M11850

08-08-12 3

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1- line drill -89 and -87 using existing pilot hole of -87 as per dwg

2- install spring pin

08-08-12 3

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/12 (x3)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:30
320
4:00

M. 08/08/12

(3x)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-13

(x3)

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Part Number: PB674300151

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Pat E*

MF 08-08-26

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/27

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-26

ORIGINAL

PREMIER AVIATION, INC.		2000 Aviation Parkway, Grand Prairie, Texas 75048	
FILE	CODE	INVEST NO.	DATE
81	050V8	867-43001	13 or 45

SCALE 0.250

① -51 LONG I-HANDLE ASSEMBLY
② -19 INNER TUBE AND RETAINER BUSHING

SCALE 0.250

4) -57 STABILIZER ARM

44-38862-6

MSH864-CALC CORRELATION (1)
3034571 LAMINATE (1)
BYPASS TUNNEL
ANALOGUE RECORD

DIV + 1 - ZENOB SPACER (1)
K44-BA BRACKET (1)
MASH845-042P WASHES (1)
MSH845-042L UNIT (1)

NO. 30 (128) THRU
100-101 SET PIN
LINE DRILL - 97
USING EXISTING PILOT HOLE

[illegible]

K. 15 KLI

RELEASED
JUN 06 01 22






58.45 REF

NO. 30 (P. 120) THRU
LINE DRILL - 89 AND - 87
USING EXISTING PILOT HOLE
OF - 87

A circuit diagram of a Wheatstone bridge. It consists of four resistors arranged in a diamond shape. The top resistor is labeled 'Variable'. The right resistor is labeled '5.13 MΩ'. The bottom resistor is labeled 'Variable'. The left resistor is labeled 'Variable'. The bridge is connected to a voltage source, represented by a battery symbol, across the top and bottom nodes.

9770h
#

